

Work Order ID 140519 **2** *split*

January 07, 2016 1:01:20 PM

140519

Page 1

Item ID: D3942-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Angle

Stop

NS2

Start Date: 1/7/2016 Start Qty: 84.00

84

74

Cust Item ID:

Required Date: 1/28/2016 Req'd Qty: 84.00

84

Customer:

Reference:

Approvals:

Process Plan: *SV*

Date: *20160107*

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3942

C

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

0.03

1-Cut as per Dwg D3942-1

Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

80

02/16/22

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.01

80

02/16/22

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 140519

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Page 2

January 07, 2016 1:01:20 PM

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 Required Date: 1/28/2016 Req'd Qty: 84.00 *84* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.03				<u>80</u>			DAS 38 9-89 FEB 23 2016
130 *130* Brake NC Brake NC	Memo 1- Bend as per dwg D3942	0.00 0.01			DAS 30 9-89	<u>80</u>			FEB 23 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.03				<u>80</u>			DAS 38 9-89 FEB 23 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 140519

140519

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>ST064A</u>	0.00				<u>80</u>		<u>MLJ</u>	<u>1602-24</u>
150									
Packaging	Memo	0.01							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160						<u>MLJ</u>		<u>FEB 2 5 2016</u>	
QC	Memo	0.14							
Quality Control									

MLJ FEB 2 5 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Page 1

Work Order ID: 140519

140519

Parent Item: D3942-1

D3942-1

Parent Item Name: Angle

Start Date: 1/7/2016

Required Date: 1/28/2016

Start Qty: 84.00

Required Qty: 84.00

Comments: Ipp Rev:A UPDATE TO REV B 10-11-24 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	389.7700	0.015	1.326316			

M304S18GA

304/316 .050 Sheet

DL 16/02/22

Location

Loc Qty

Loc Code

MAT020

382.07

M128435

22.37

M132797

5

M133328

214.7

M133587

140

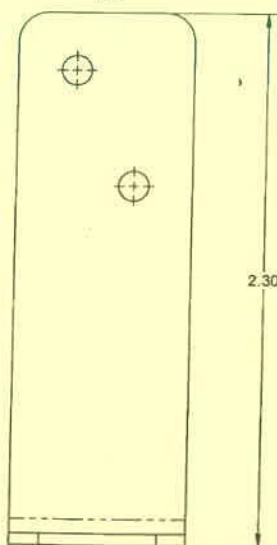
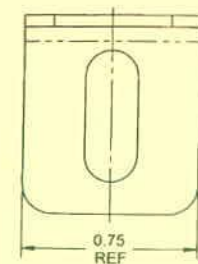
MAT20

7.7

M131700

7.7

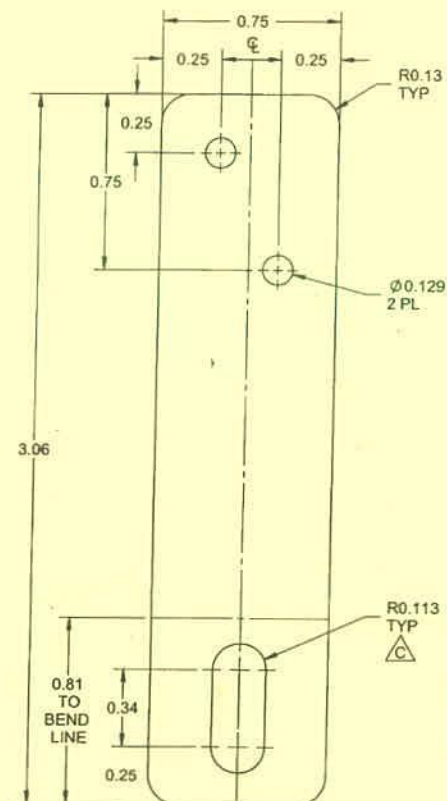
1.5



0.050
REF

R0.06

D3942-1F ANGLE
MADE FROM D3942-1F



R0.113
TYP
C



D3942-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524
18 GAUGE (0.050 THICK)
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

C	INCREASE SLOT/HOLE SIZE TO ALLOW PROPER FITTING OF PANEL : 0.113 WAS 0.094, ZN B2-1, 0.275 WAS 0.257, ZN C5-2 (REF PAR 10-006)	XDF	11.09.02
B	REVISE LENGTH OF -3 PART, ZN C3-2: UPDATE IDENTIFICATION, ZN A7-1, A7-2	HS	10.11.19
A	NEW ISSUE	HS	09.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.09.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3942** REV. C
SHEET 1 OF 2
TITLE **BRACKET** SCALE NTS

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140519
20160107 Slt

0.050
REF

$\phi 0.129$
2 PL

$\phi 0.275$
 $\triangle C$

0.31

0.38

2.50

R0.13
TYP

D3942-3 CLIP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524
18 GAUGE (0.050 THICK)
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	XDF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3942	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.09.02	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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2011-12-12

